

Work Order ID 59440

Friday, June 04, 2010 10:26:37 AM



Page 1

Item ID: D4040-1

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 6/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4040

A

100 Cut blanks as per folio

0.00



Bandsaw

Memo

CUT BLANK 6.050" LONG

0.00

105



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA890

DWG REV: A
FOLIO REV: A

0.00

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59440

Friday, June 04, 2010 10:26:37 AM



Page 2

Item ID: D4040-1

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 6/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

2010/06/06

0.00

12 08

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Y.A 10/06/06

0.00

12 08

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

7M.L 10/06/07

12X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59440

Friday, June 04, 2010 10:26:37 AM



Page 3

Item ID: D4040-1

Accept



Setup

Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 6/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

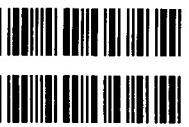
Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

12

Bp 10-6-7.

QC

Quality Control

160

Identify as per dwg & Stock Location: 5118 0.00

Packaging

Packaging

Memo

0.00

12
BB
10/06/08

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/06/09
MF
10-6-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 10:26:41 AM

Page 1

Work Order ID: 59440



Parent Item: D4040-1



Parent Item Name: Radius Block

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X0.75 0		Purchased	No			100	f	24.0631	0.09	1.136842			

6061T6 BAR .375 x .750



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	24.0631	
110829	4.0631	
113719	20	

1.1368 *mk 10/06/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59440
Description: RADIUS BLOCK	Part Number:	D4D4b-1
Inspection Dwg: D4D4b Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>On</i>	Audited by:	<i>J. A.</i>	Prototype Approval:	N/A
Date:	<i>10/06/06</i>	Date:	<i>10/06/06</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJJLM	

8

7

6

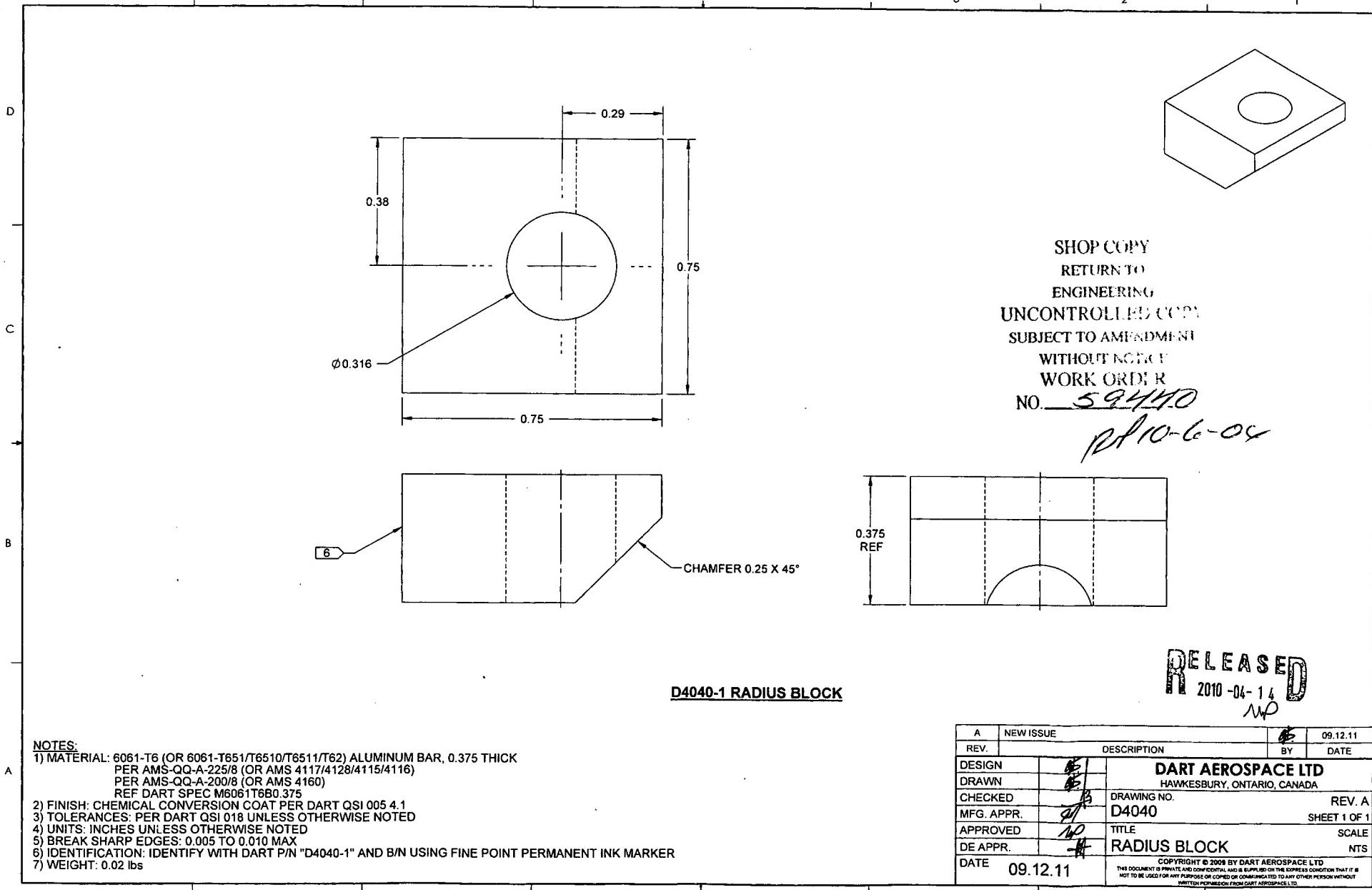
5

4

3

2

1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries